

Date: Wednesday, 15/04/2009 9:48:59 AM
 User: Julie Dawson

Process Sheet

| | |
|---|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : GASKET |
| Job Number : 47212 | |
| Estimate Number : 13311 | |
| P.O. Number : | Part Number : D37941 |
| This Issue : 15/04/2009 S.O. No. : | Drawing Number : D3794 REVA |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : A |
| Previous Run : 46530 | Material : |
| Written By : | Due Date : 23/04/2009 Qty: 12 Um: Each |
| Checked & Approved By : <u>JUD 09.04.15</u> | |
| Comment : Est Rev:A 08-05-13 new issue DD verified by:EC Est Rev:B 08-05-23 revA as per dwg DD verified by:EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|------------|----------------------|
| 1.0 | MNEO60S063 | NEOPRENE SHEET 0.063 |
|-----|------------|----------------------|



Comment: Qty.: 0.6374 sf(s)/Unit Total : 7.6490 sf(s)

NEOPRENE SHEET 0.063

Batch: 111469 1B9-4-30

| | | |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3794

Dwg Rev: A

Prog Rev: 1

1B9-4-30

(12)

2-Deburr if necessary

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



1B9-4-30

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

502/05/01 (12)

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Finishing Dept.

88 502/05/01 (12)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 15/04/2009 9:48:59 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 47212

Part Number: D37941

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/04 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-05-01

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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NOTE: Date & initial all entries

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|------------------------------|--|--------------|---------|
| DART AEROSPACE LTD | | Work Order: | 47212 |
| Description: Gasket | | Part Number: | D3794-1 |
| Inspection Dwg: D3794 Rev: A | | Page 1 of 1 | |

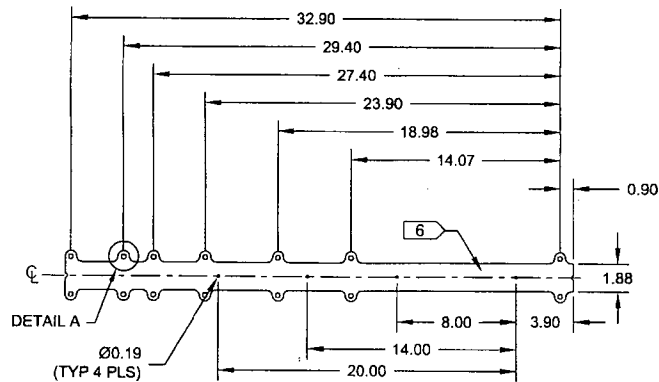
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

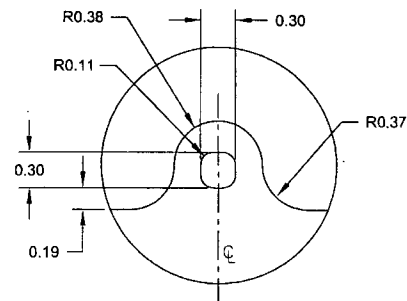
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.19 | +0.005/-0.001 | .190 | * | | | |
| 0.300 x 0.300 | +/-0.010 | .279 x .299 | * | | | |
| 1.88 | +/-0.030 | 1.892 | * | | | |
| 0.90 | +/-0.030 | .90 | * | | | |
| 3.90 | +/-0.030 | 3.903 | * | | | |
| 8.00 | +/-0.030 | 8.00 | * | | | |
| 14.00 | +/-0.030 | 14.00 | X | | | |
| 20.00 | +/-0.030 | 20.00 | * | | | |
| 14.07 | +/-0.030 | 14.07 | * | | | |
| 18.98 | +/-0.030 | 18.98 | * | | | |
| 23.90 | +/-0.030 | 23.90 | * | | | |
| 27.40 | +/-0.030 | 27.40 | * | | | |
| 29.40 | +/-0.030 | 29.40 | * | | | |
| 32.90 | +/-0.030 | 32.90 | * | | | |
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| Measured by: IB | Audited by: S | Prototype Approval: | N/A |
| Date: 9-4-30 | Date: 09/05/01 | Date: | N/A |

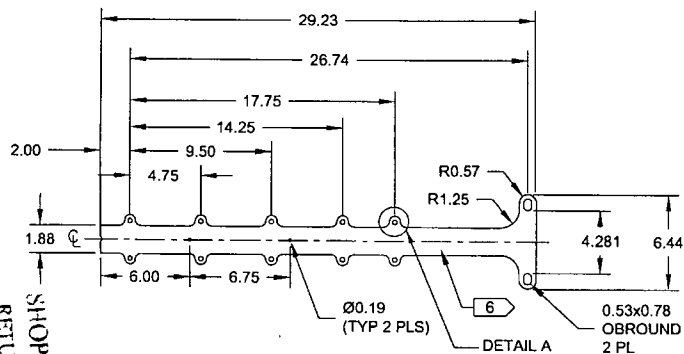
| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 08.05.28 | New Issue | KJ/DD | IB |



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

RELEASED
08-05-14

- NOTES:**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
 - 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

| | | | |
|------------|-------------|---|--------------|
| A | NEW ISSUE | PH | 08.05.14 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | PH | DART AEROSPACE USA, INC PORT HADLOCK, WA | |
| DRAWN | PH | | |
| CHECKED | PH | DRAWING NO. | REV. A |
| MFG. APPR. | PH | D3794 | SHEET 1 OF 1 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | GASKET | NTS |
| DATE | 08.05.14 | COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC | |